



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

649.4902

Job Sheet 186021



9011
Dec 12

Part No: 649.4902

Job Qty: 4 ea

Part Name: Lower Cutter Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/8/18

Job Tracking No:

Due Date: 11/29/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A IPP REV: A 12.11.01 NEW ISSUE DD VERF: JLM

Ship Via:

066 528

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	11/29/18	11/29/18	0.00	0.00	Start Up Stores/Pkg-1	6.00	NOV 19 2018
110	Packaging	4 pcs	11/29/18	11/29/18	0.00	0.00	Packaging1-1	6.00	NOV 19 2018
120	Small Fab	4 pcs	11/29/18	11/29/18	0.00	0.10	Small Fab-1	6.00	DEC 17 2018
130	QC	4 pcs	11/29/18	11/29/18	0.00	0.00	QC5	6.00	DEC 18 2018
140	Packaging	4 pcs	11/29/18	11/29/18	0.00	0.00	Packaging3-1	6.00	DEC 18 2018
150	QC21-SA	4 Ea	11/29/18	11/29/18	0.00	0.00	QC21	6.00	DEC 18 2018

Part Op 120 - Assemble as per dwg Apply RTV TO ALL FAYING SURFACES RTV 598 BATCH:
Descriptions: 140 - ***IDENTIFY AS DWG PER APICAL MPP-120 BY LASER ETCH THE P# AND REV***

Printer 5094268

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
649.5301	Lower Deflector Assembly	4 Ea (1 ea)	90-Start up Operation	F136200X1 S006208x 3
649.8301	Cutter Sub Assembly	4 Ea (1 ea)	90-Start up Operation	5127450
MS21042L08	Nut	12 Ea (3 ea)	90-Start up Operation	5100909
MS27039-08-19	Screw	12 Ea (3 ea)	90-Start up Operation	5104359
NAS1149FN832P	Washer	24 Ea (6 ea)	90-Start up Operation	5107196

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	649.5301	4	4	0
	649.8301	4	3	0
	MS21042L08	12	1,728	0
	MS27039-08-19	12	1,598	0
	NAS1149FN832P	24	2,487	0



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: \$128971



Part: 649.4902

Job No: 186021

Serial No/Batch: \$128971

Revision:
Inspector:
Exp Date:
Instructions:

Date: 11/19/18

Plex 11/8/18 10:23 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

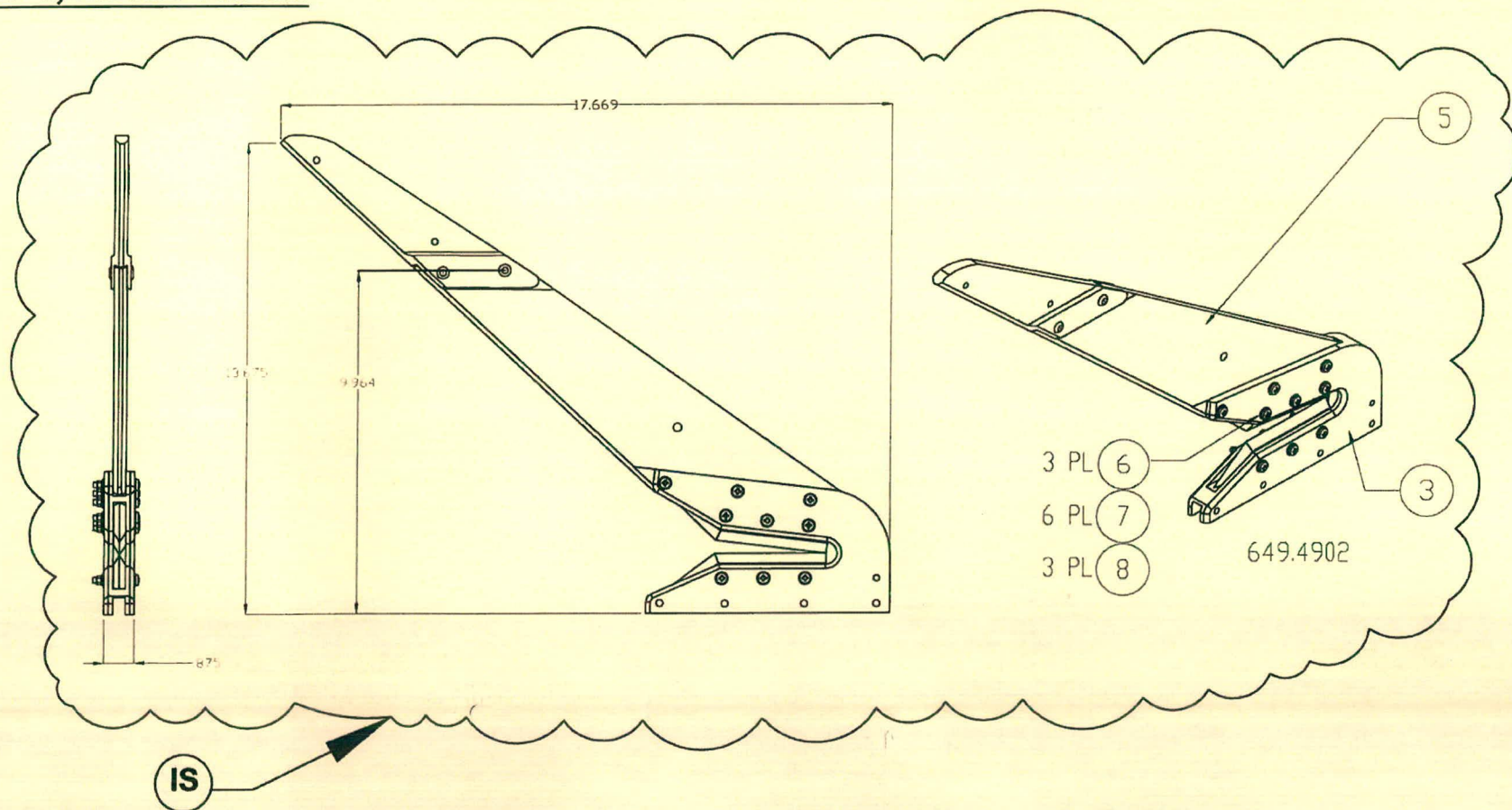
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

APICAL INDUSTRIES, INC.	ENGINEERING CHANGE NOTICE NO. 03526				SHEET 1 OF 1	
	DWG NO. 649.4900	REV: A	PREPARED BY S. COCHRAN	DATE: 05-29-12	EFFECT ON DWG ☐ INC. ☒ UNINC.	
	DWG TITLE: CUTTER ASSY					
APPROVED BY: ENGR <i>[Signature]</i>		MFG <i>[Signature]</i>	QC <i>[Signature]</i>	EFF: CURRENT STOCK & NEXT ORDER		
TRANSACTION CODES (TC): A-ADD C-CREATE R-REVISE D-DELETE		REASON: REVISED INSPECTION DIMENSIONS				

SHEET 1, ZONE D2 IS:



DOCUMENTS EFFECTED:	☐ MDL ☐ INSTALL INSTRUC ☐ ICA ☐ BOM	CHANGE CATEGORY ☐ MAJOR ☒ MINOR	DER REVIEW REQUIRED ☐ YES ☒ NO
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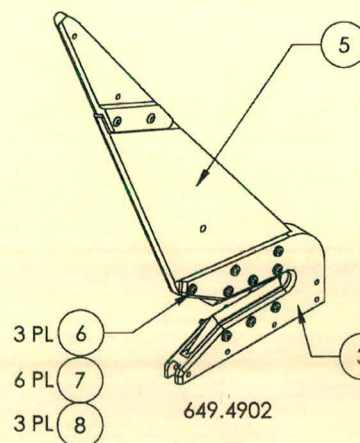
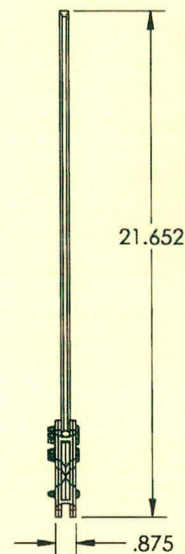
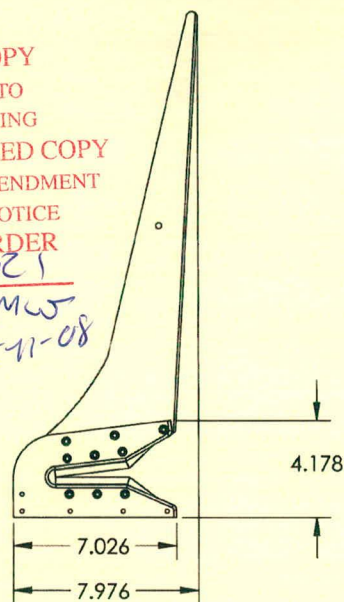
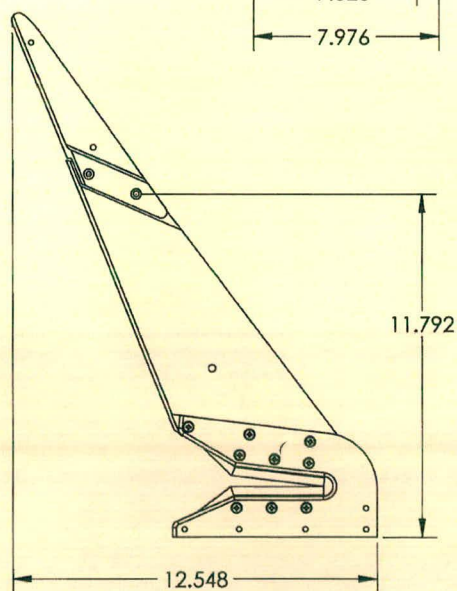
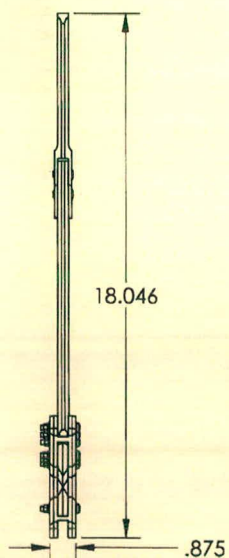
1. IDENTIFY IAW MPP-120.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 186021

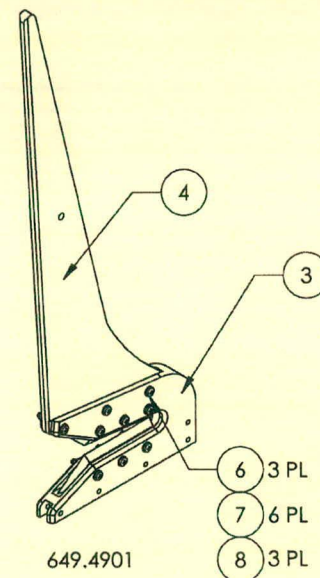
MW
18-11-08

UNINCORPORATED ECN(s)

03526



REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
N/C	LAST PROTOTYPE REVISION: P12		N/A
N/C	INITIAL RELEASE	12-07-11	P. BRAVO
A	INCORPORATED ECN 03487 & 03470	04-17-2012	J. GARDNER



3	3	8	601.1541	LOCKNUT	MS21042L08	
6	6	7	601.2764	WASHER	NAS1149FN832P	
3	3	6	601.2765	SCREW	MS27039-0819	
1		5	649.5301	LOWER DEFLECTOR	ASSY	
	1	4	649.5311	UPPER DEFLECTOR		
1	1	3	649.8301	CUTTER SUB ASSY		
		2	649.4902	LOWER CUTTER ASSY		
		1	649.4901	UPPER CUTTER ASSY		
.4902	.4901	FIND #	PART #	DESCRIPTION	MAT'L	SPEC.

QTY		ORIGINAL DATE		PARTS LIST	
NEXT ASSY (S)		04-17-2012		APICAL INDUSTRIES	
		DRAWN BY: J. COCHRAN		2608 TEMPLE HEIGHTS DR.	
		DRAWING APPROVAL: P. BRAVO		OCEANSIDE, CA. 92056-3512 (760)724-5300	
		CONTRACT NO.		CUTTER ASSY	
		UNLESS OTHERWISE SPECIFIED		SEE CAGE CODE	
		DIMENSIONS ARE IN INCHES		DWG. NO. 649.4900	
		TOLERANCES ARE:		REV. A	
		2 PLACE DECIMALS ±.010		SCALE NONE	
		3 PLACE DECIMALS ±.005		SHEET 1 OF 1	
		ANGLES ±.5°			

Linda Lacelle

From: Linda Lacelle
Sent: Wednesday, November 7, 2018 11:21 AM
To: Patrick Duval; Caitlin Crooks
Cc: Jason Leroux; Jean-Luc Menard; Marc Bellavance
Subject: RE: 649.4701- rev C
Attachments: 649.4900 A1 CUTTER ASSY.pdf

Thx Pat
Pls see below

From: Patrick Duval
Sent: Tuesday, November 6, 2018 5:43 PM
To: Caitlin Crooks <ccrooks@dartaero.com>; Linda Lacelle <llacelle@dartaero.com>
Cc: Jason Leroux <jleroux@dartaero.com>; Jean-Luc Menard <jmenard@dartaero.com>; Marc Bellavance <mbellavance@dartaero.com>
Subject: RE: 649.4701- rev C

Linda,
Here's a quick list of what I will need in order the make my kit to rev C.

649.5111 need some at rev A1 (got some in quarantine) – are these good to use?
649.5112 need some at rev A1 (got some in quarantine) – are these good to use?
649.4811 need some at rev A – WJ>OS – approx. 3wks
649.4816 need some at rev A – WJ>OS – approx. 3wks
649.4813 need some at rev A – WJ>OS – approx. 3wks
649.5214 need some at rev A – Machining>OS- approx. 4-5wks aro
649.5010 need some at rev C1 – Machining>OS- approx. 4-5wks aro
649.4902 need some at rev A – do the 649.5301 and 649.8301 need to be at an older rev? see attached

x 4 each

Rev A?

Also for me to complete the kit from RA173 we will need to add, remove some of the hardware to make it as per rev C.

Sorry for the delay... this is a big mess and I don't what to rush and ship something that's not good.

Pat Duval
QC Coordinator

